

Date: Thursday, 6/21/2007 2:29:58 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 33075		
Estimate Number	: 12322		
P.O. Number	: <i>N/A</i>	Part Number	: D3492041
This Issue	: 6/21/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3492 REV B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 32996	Drawing Revision	: B
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 7/3/2007
Checked & Approved By	: <i>[Signature]</i> 07.06.22	Qty:	80 Um: Each
Comment	: est rev A 06.03.03 New Issue EC Est Rev:B 06-08-28 As per Rev B JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 5.2500 f(s)
 6061-T6 Round Bar .625"
 (M6061T6R0625)
 Batch: *10104/89 103884*

20 9/08/12

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 & Dwg D3492
 Dwg Rev: *B*
 Folio Rev: *ΔΔ*

20 07/08/12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/08/12

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

20 07/08/12

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

ml 07/08/12

X 80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/09/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLUG

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Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



80x

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L

07/08/22

7.0

POWDER COATING

POWDER COATING



80x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

M-L

07/08/29

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



80x

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

07/08/29

9.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 80.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-010 O-RING

M103272 (x34) m104885 (416)

FL

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



80x

Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: m101223

FL

11.0

QC5

INSPECT WORK TO CURRENT STEP



80x

Comment: INSPECT WORK TO CURRENT STEP

m1070906

12.0

PACKAGING 1

PACKAGING RESOURCE #1



80x

Comment: PACKAGING RESOURCE #1

FP 16

M-L

07/09/06

13.0

QC21

FINAL INSPECTION/W/O RELEASE



80x

Comment: FINAL INSPECTION/W/O RELEASE

07/09/06

Job Completion



U 07/09/06

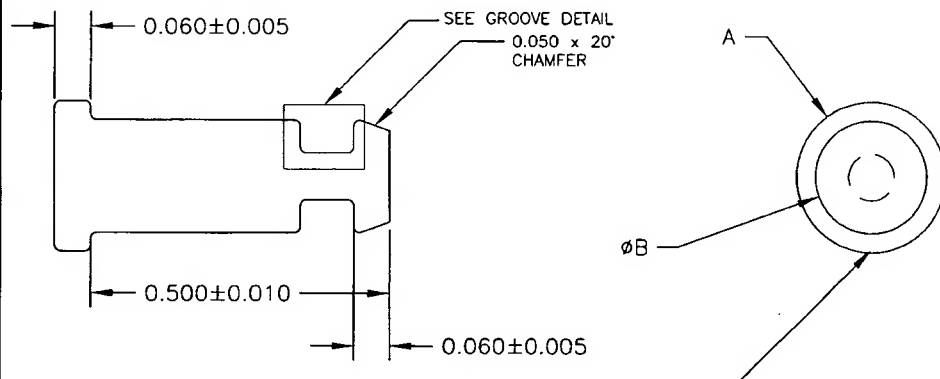
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

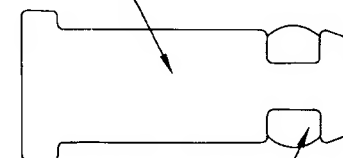
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1

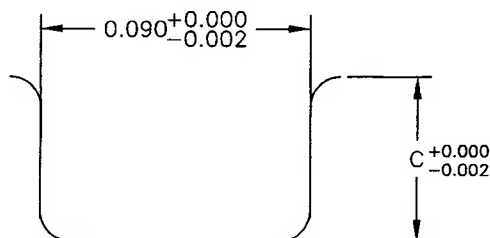
D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

RELEASED
06.10.04 PH
P/R ECU #351



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500

B

D3492-1/-3/-5/-7 PLUG NOTES

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

NO. 33075
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING

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B	06.05.11	ADD -047; UPDATE DIM A, -045
A	06.01.04	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.05.11	TITLE
		PLUG
		DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
		DRAWING NO. D3492
		REV. B
		SHEET 1 OF 1
		SCALE
		NTS

DART AEROSPACE LTD		Work Order:	32294
Description: Plug		Part Number:	D3492-1
Inspection Dwg: D3492 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.061				
0.060	+/-0.005	.061				
Ø0.394	+0.006/-0.001	.395				
Ø0.625	+0.008/-0.001	.625				
0.090	+0.000/-0.002	.089				
0.500	+/-0.010	.500				
0.055	+0.000/-0.002	.054				
NOT 33075 Same as 32294 [Signature]						

Measured by:	[Signature]
Date:	07/08/12

Audited by:	[Signature]
Date:	07/08/12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.02	New Issue P/O D3492-041	KJ/JLM	
B	06.10.16	Ø0.625 was Ø0.500	KJ/JLM [Signature]	[Signature]